Amendments to the Claims

This listing of claims will replace all prior listings of claims in the application.

Listing of Claims

1. (Canceled)

2. (Currently Amended) Method for the manufacture of heat-exchanger tubes according to ~~claim 17~~claim 18, characterized in that the drawn tube material or the tube portions are subjected to quality control.

3. (Currently Amended) Method for the manufacture of heat-exchanger tubes according to ~~claim 17~~claim 18, characterized in that the drawn heat-exchanger tube material is flushed with inert gas.

4. (Previously Presented) Method for the manufacture of heat-exchanger tubes according to claim 3, characterized in that the inert gas flows counter to the direction in which the drawn heat-exchanger tube material is uncoiled.

5. (Previously Presented) Method for the manufacture of heat-exchanger tubes according to claim 2, characterized in that after cutting into tube portions, defective tube portions are sorted out after the quality control.

6. (Withdrawn) Method for the manufacture of heat-exchanger tubes according to claim 17, characterized in that, after cutting to the desired length, the tube portions are subjected to internal and/or external cleaning.

7. (Withdrawn) Method for the manufacture of heat-exchanger tubes according to claim 17, characterized in that

either the drawn heat-exchanger tube material is annealed in a continuous operation or the tube portions are annealed in a batch operation.

8. (Withdrawn) Method for the manufacture of heat-exchanger tubes bent in a U-shape according to claim 17, characterized in that, after straightening and before testing, the drawn heat-exchanger tube material is subjected to a ribbing process.

9. (Withdrawn) Method for the manufacture of heat-exchanger tubes according to claim 17, characterized in that when the drawn heat-exchanger tube material is annealed before cutting into tube portions, the drawn heat-exchanger tube material is deposited on a basket winder and further processed on a single- or multiple-bending device.

10. (Withdrawn) Production line for the manufacture of tubes bent in a U-shape from a nonferrous metal, immediately following a tube-production line, comprising:

a) a storage device having an uncoiling device (2) for drawn tube material (1),
b) a straightening facility for the uncoiled drawn tube material (1) and testing facility (3),
c) an annealing unit (4) and a following cooling unit (5) for the drawn tube material (1) before or after a cutting unit (11), for separation into tube portions, for cutting to the starting length or a multiple of the starting length for a tube (20) bent in a U-shape,
d) a bending device (21) for bending the tube portions into a U-shape.

11. (Withdrawn) Production line for the manufacture of tubes bent in a U-shape according to claim 10, characterized in that, in order to flush the drawn tube material (1), an

inert gas flushing unit (7) is arranged at one end of the tube and a suction apparatus (8) is arranged at the other end.

12. (Withdrawn) Production line for the manufacture of tubes bent in a U-shape according to claim 10, characterized in that the cutting unit (11) is followed by a sorting apparatus (12) for different lengths of the tube portions (10).

13. (Withdrawn) Production line for the manufacture of tubes bent in a U-shape according to claim 12, characterized in that a cleaning apparatus (13) is arranged downstream of the cutting unit (11) or optionally downstream of the sorting apparatus (12).

14. (Withdrawn) Production line for the manufacture of tubes bent in a U-shape according to claim 10, characterized in that the annealing unit (4) for the drawn tube material (1) in continuous operation or for the separated tube portions (10) in batch operation is an induction, radiation or convection furnace.

15. (Withdrawn) Production line for the manufacture of tubes bent in a U-shape according to claim 10, characterized in that the straightening facility (3) is followed by a ribbing apparatus (9) for the drawn tube material (1).

16. (Withdrawn) Use of the tubes (20) manufactured according to the method according to claim 1 and bent in a U-shape for heat exchangers.

17. (Canceled)

18. (New) A method of manufacturing lamellar U-shaped heat-exchanger tubes, comprising the steps of:

producing a drawn heat-exchanger tube material made of a nonferrous metal;

coiling the drawn heat-exchanger tube material horizontally in a round open-top container;

uncoiling the drawn heat-exchanger tube material from the container;

straightening the uncoiled drawn heat-exchanger tube material;

forming a recrystallized state in the drawn heat-exchanger tube material by annealing and subsequently cooling the drawn heat-exchanger tube material;

cutting the drawn heat-exchanger tube material having the recrystallized state to form tube portions of a desired length; and

bending the tube portions into a U-shape to form the lamellar U-shaped heat-exchanger tubes.

19. (New) A method of manufacturing lamellar U-shaped heat-exchanger tubes, comprising the steps of:

producing a drawn heat-exchanger tube material made of a nonferrous metal;

coiling the drawn heat-exchanger tube material horizontally in a round open-top container;

uncoiling the drawn heat-exchanger tube material from the container;

straightening the uncoiled drawn heat-exchanger tube material;

cutting the drawn heat exchanger tube material to form tube portions of a desired length;

forming a recrystallized state in the tube portions by annealing and subsequently cooling the tube portions; and

bending the tube portions into a U-shape to form the lamellar U-shaped heat-exchanger tubes.

20. (New) Method for the manufacture of heat-exchanger tubes according to claim 19, characterized in that the drawn tube portions are subjected to quality control.

21. (New) Method for the manufacture of heat-exchanger tubes according to claim 19, characterized in that the drawn heat-exchanger tube material is flushed with inert gas.

22. (New) Method for the manufacture of heat-exchanger tubes according to claim 21, characterized in that the inert gas flows counter to the direction in which the drawn heat exchanger tube material is uncoiled.

23. (New) Method for the manufacture of heat-exchanger tubes according to claim 20, characterized in that, after cutting to the desired length, the tube portions are subjected to internal and/or external cleaning.